

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023584**Date Inspected:** 05-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Shi Lei

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

This QA Inspector observed ZPMC welder Mr. Zhao Aifei stencil 067942 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 13CW weld SEG3020AF-003. This QA Inspector observed a welding current of approximately 170 amps, the base material had been preheated with electric heaters and Mr. Zhao Aifei appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yu Hui Ye, stencil 045143 used flux cored welding procedure specification WPS-B-T-2231-ESAB to perform OBG segment 13CW weld SA3127-017-009 and 011. This QA Inspector observed a welding current of approximately 310 amps, 26.5 volts, the base material had been preheated with electric heaters and Mr. Yu Hui Ye appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Mr. Yu Hongwei, stencil 058245 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 13CW weld SEG3015K-207. This QA Inspector observed a welding current of approximately 290 amps, 26.0 volts, the base material had been preheated with electric heaters and Mr. Yu Hongwei appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Rucheng, stencil 066881 used flux cored welding procedure WPS-B-T-2231T-ESAB-1 to make weld OBW13B-003. This QA Inspector observed a welding current of approximately 320 amps, 26.5 volts, the base material had been preheated with electric heaters and Mr. Wang Rucheng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Huang Hongpei, stencil 037705 used flux cored welding procedure WPS-B-T-2132-ESAB to make OBG segment 14W weld SEG3020C-057. This QA Inspector observed a welding current of approximately 310 amps, 26 volts, the base material had been preheated with electric heaters and Mr. Huang Hongpei appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Li Bin, stencil 069896 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U5B-FCM-1 to make OBG segment 14W weld SEG3020D-151. This QA Inspector observed a welding current of approximately 170 amps, the base material had been preheated with electric heaters and Mr. Li Bin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Lv Feng Bao, stencil 045175 used flux cored welding procedure WPS-B-T-2231T-ESAB-1 to make weld OBW13E-003. This QA Inspector observed a welding current of approximately 270 amps, 27.0 volts, the base material had been preheated with electric heaters and Mr. Lv Feng Bao appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Guijun, stencil 067275 used flux cored welding procedure WPS-B-T-2231T-ESAB-1 to make weld OBW13D-003. This QA Inspector observed a welding current of approximately 245 amps, 26.5 volts, the base material had been preheated with electric heaters and Mr. Wang Guijun appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
